

# Work Order ID 67002

Thursday, March 03, 2011 10:46:19 AM



Page 1

Item ID:	D3245-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Assembly					
Start Date:	3/3/2011	Start Qty:	5.00	Cust Item ID:		
Required Date:	3/7/2011	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>M</u>	Date:	<u>11-03-3</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3245	Rev B								
100	Pick Kit	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
110	Small Fab	0.00							
	Small Fab								
	Small Fab								
	Memo	0.00							
	1-Install Studs and Gromets as per Dwg D3245□3-Bond Gasket using 3M								
	ADHESIVE as per Dwg D3245□A/R 3M 1300/1300L ADHESIVE								
	Batch: <u>M115230</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							

Ep 11/03/07 (5)

Ep 11/03/07 (5)

SB 11/04/11

SB 11/04/11

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 67002



Thursday, March 03, 2011 10:46:19 AM





Page 2

Item ID: D3245-043 Accept  Setup Start   
Revision ID: Stop   
Item Name: Door Assembly  
Start Date: 3/3/2011 Start Qty: 5.00  Cust Item ID:  
Required Date: 3/7/2011 Req'd Qty: 5.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <b>233A</b>	0.00							
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/4/12 

11/4/12   
MF  
11-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

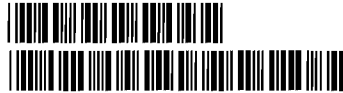
Thursday, March 03, 2011 10:46:28 AM

Page 1

Work Order ID: 67002

Parent Item: D3245-043

Parent Item Name: Door Assembly



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

127H-35 		Purchased	No			100	Each	5.0000	8	40			
HALF GROMMET													

Location	Loc Qty	Loc Code
ST378	5	B117203
116049	5	

2351-20-009-C3Y 		Purchased	No			110	Each	70.0000	8	40			
STUD													

Location	Loc Qty	Loc Code
ST399	70	M117358
106484	1	
110944	50	
111733	13	
15447	6	

D3245-3 		Manufactured	No			110	Each	10.0000	1	5			
Door													

Location	Loc Qty	Loc Code
ST233	6	
63604	6	
ST233A	4	
63598	4	

Handwritten notes and signatures:

- 11/04/11
- 40
- 11/04/11
- 40
- 5/3/07
- 1
- 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, March 03, 2011 10:46:28 AM

Work Order ID: 67002



Parent Item: D3245-043



Parent Item Name: Door Assembly

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 5.00

Required Qty: 5.00

D3245-7

Manufactured

No

110

Each

5.0000

1

5



Gasket



*Handwritten signature and date: 3/3/07*

Location

Loc Qty

Loc Code

ST233B

5

63366

5

Thursday, March 03, 2011 10:46:28 AM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

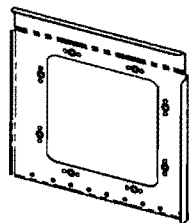
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



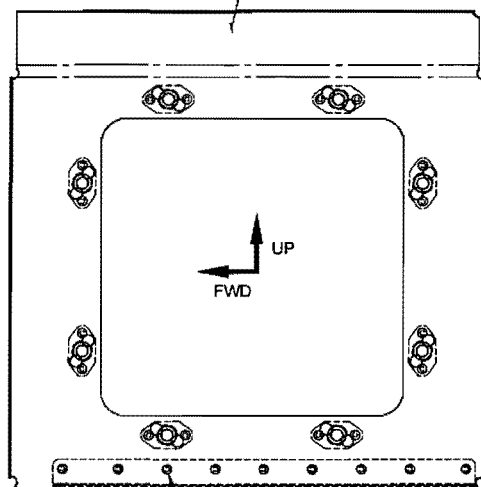
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RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67002



D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



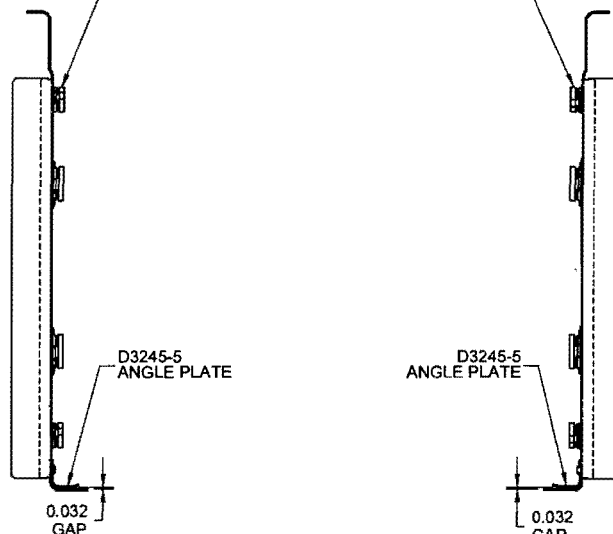
MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07-10-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

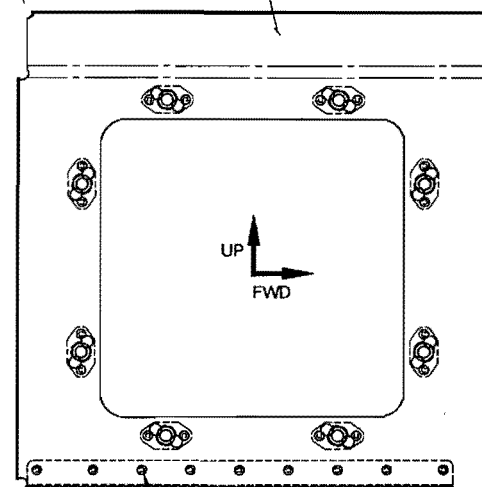
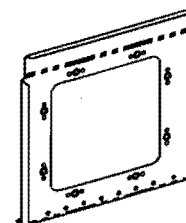


D3245-5  
ANGLE PLATE

0.032  
GAP

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1		D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

B		REMOVE Ø0.204 HOLES FROM D3245-1/-2. REMOVE MS21060-1.3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	JH			DART AEROSPACE LTD	
DRAWN	JH			HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH			DRAWING NO.	REV. B
MFG. APPR.	JH			D3245	SHEET 1 OF 7
APPROVED	JH			TITLE	SCALE
DE APPR.	JH			ACCESS PANEL ASSEMBLY	1:2.5
DATE		07.10.02		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR CONSUMED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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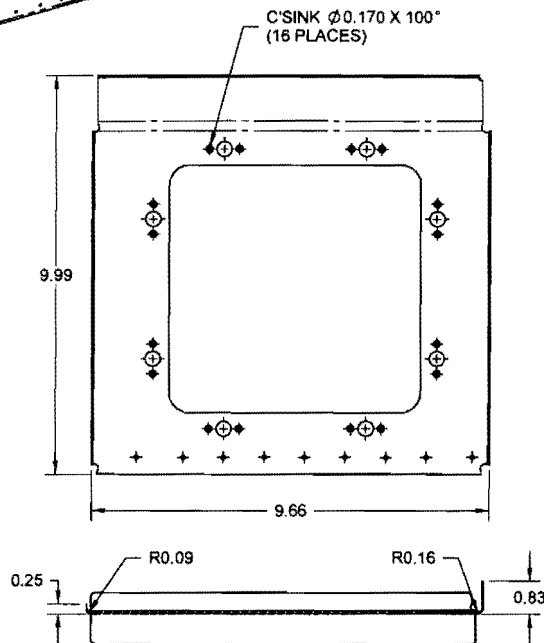
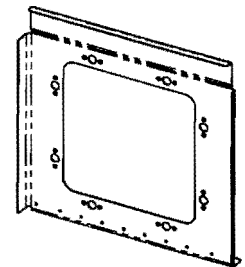
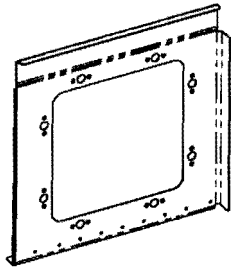
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

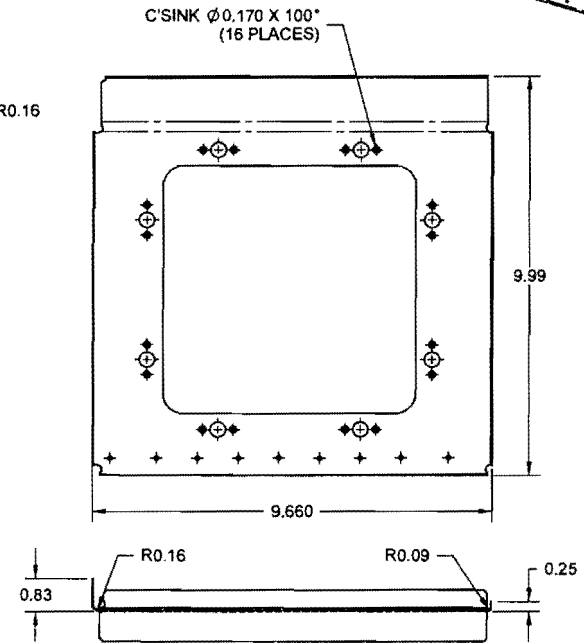
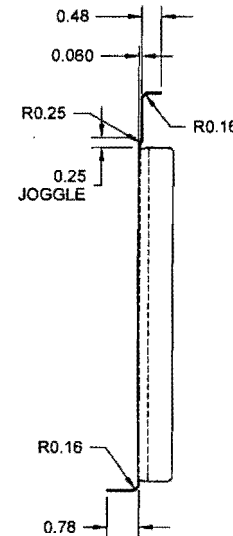
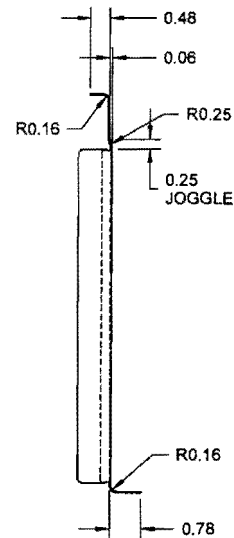
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 67002  
2111-03-3



**D3245-1 PANEL BEND DETAIL, LH**



**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
2111-10-23

- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

DESIGN	<u>TH</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>PH</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<u>PH</u>		SHEET 2 OF 7
APPROVED	<u>PH</u>	TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:3
DE APPR.	<u>PH</u>	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

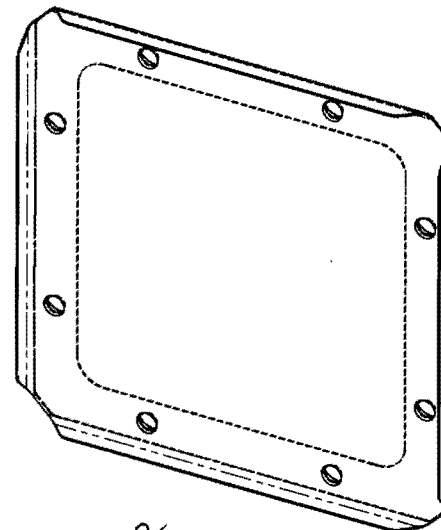
D3245-7 GASKET  
(REF)

8.00  
(TYP, REF)

**D3245-043 DOOR ASSEMBLY**



INSTALL D3245-7  
GASKET ON THIS SIDE



w/o 67062

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

**RELEASED**  
(WP 27-10-33)

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3245</b> REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE <b>ACCESS PANEL ASSEMBLY</b> SCALE 1:2
DE APPR.	<i>[Signature]</i>	
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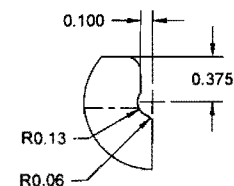
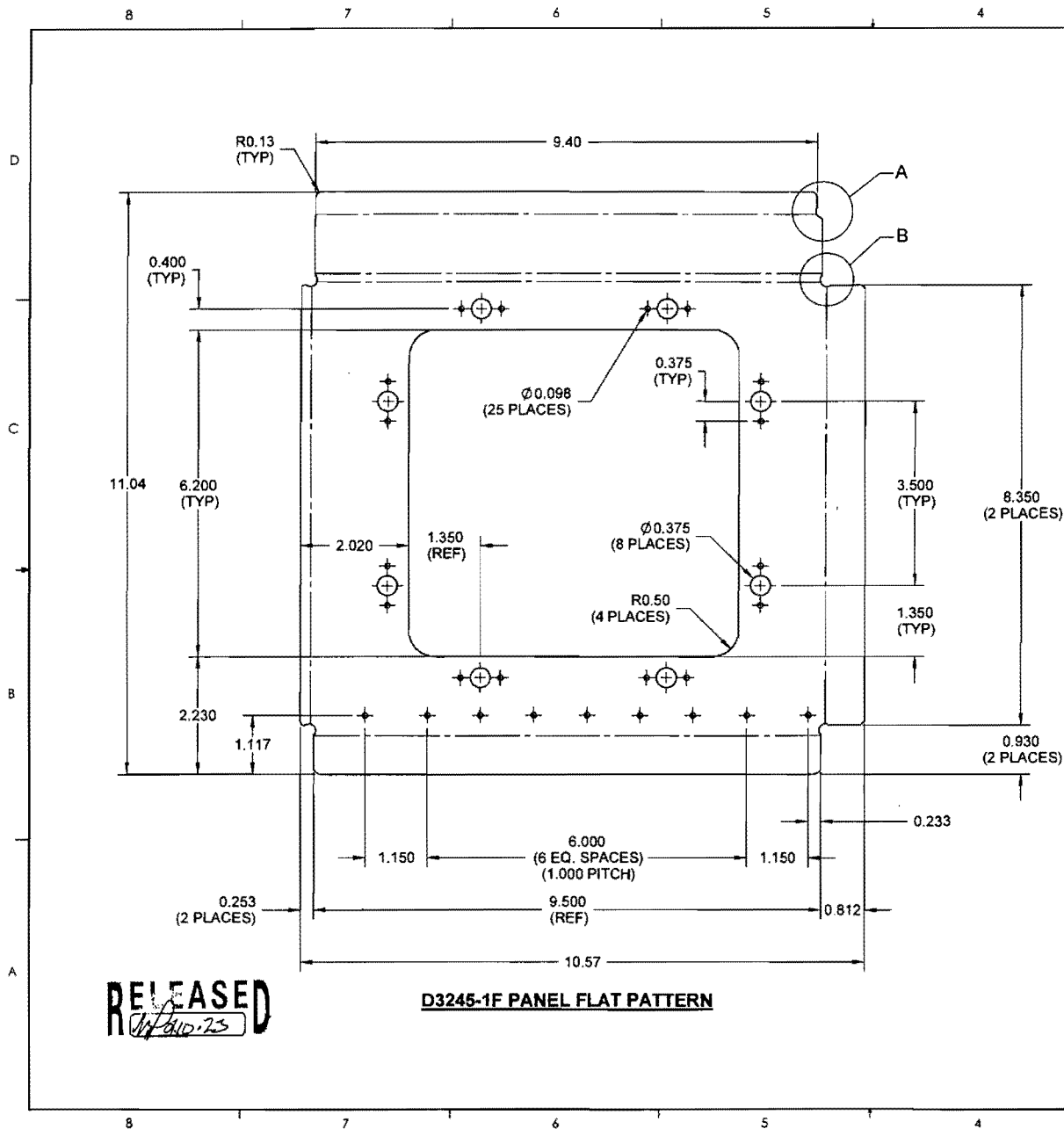
**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

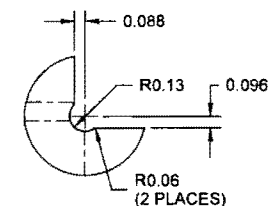
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET  
(0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3245</b>	REV. 8
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	1:2	

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**RELEASED**  
*[Signature]*

# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

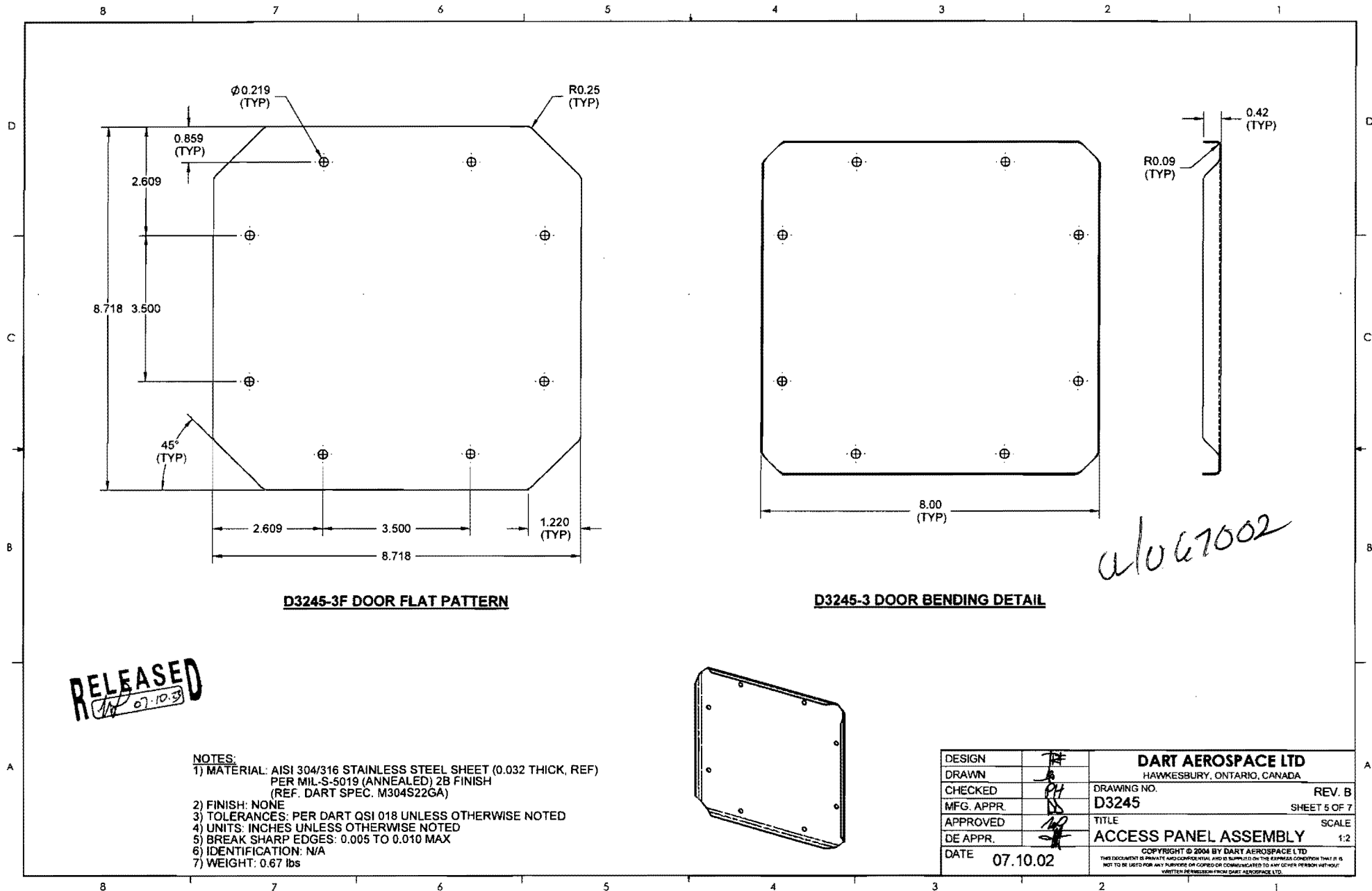
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

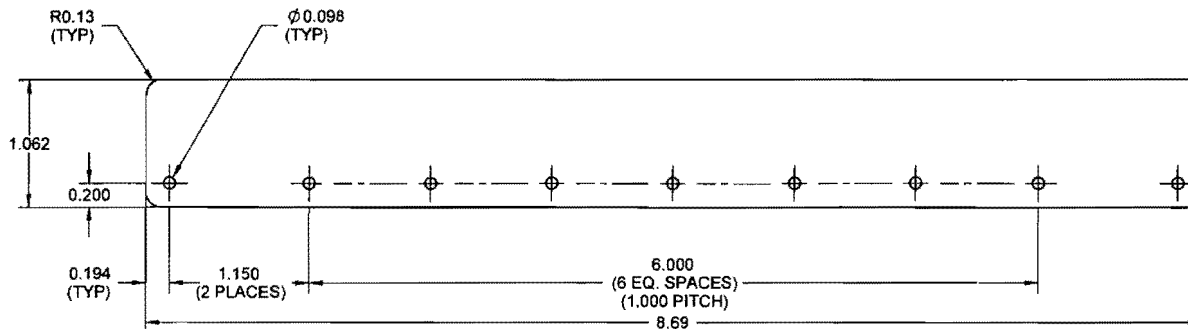
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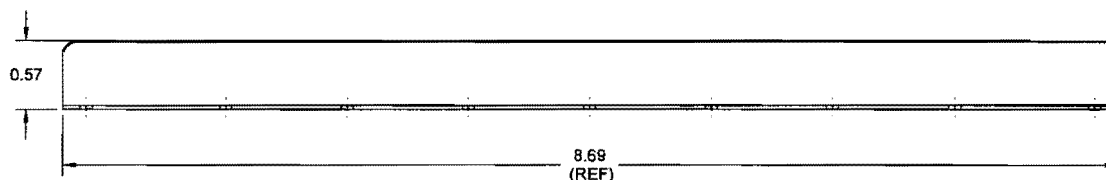
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D

D

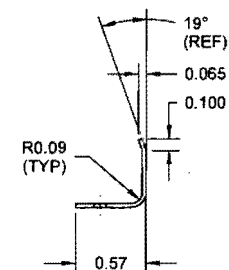


**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)

*u1067002*



**RELEASED**  
*07.10.23*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>TH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>TH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>TH</i>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<i>TH</i>	SHEET 6 OF 7	
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	<b>ACCESS PANEL ASSEMBLY</b>	1:1
DATE	<b>07.10.02</b>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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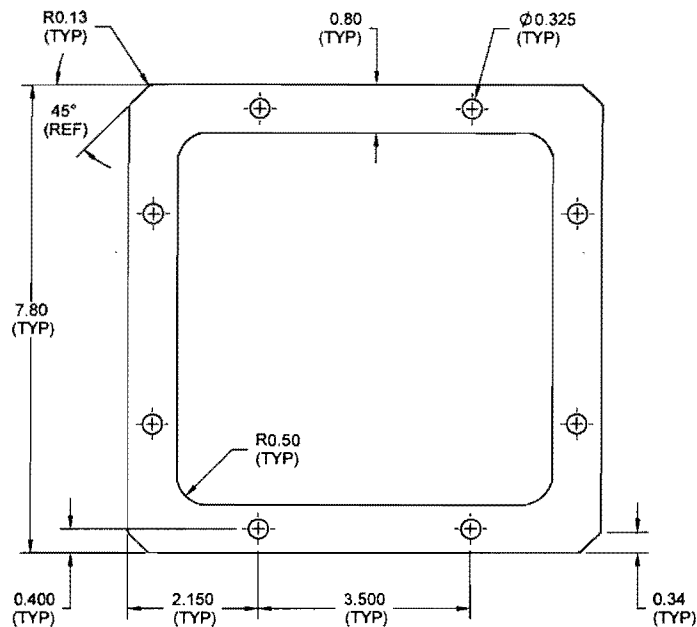
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

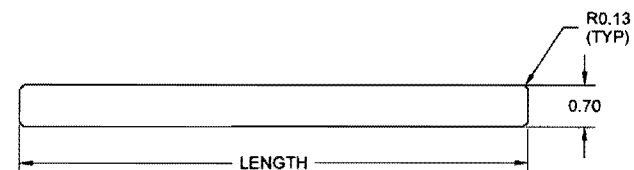
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<i>PH</i>		SHEET 7 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries